

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001827**Date Inspected:** 19-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG Deck Panel	

**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) Inspector Roscoe Dixon was present at the time requested to perform visual weld inspections for the Orthotropic Box Girders (OBG).

**Bay 1 OBG:**

The Caltrans QA Inspector performed visual inspection on the completed submerged arc welding, (SAW) cover pass welds and partial joint penetration (PJP) welds joining the closed rib to deck panel DP299-001, u-rib U-35, welds 1&2; u-rib U-55, welds 2&3; u-rib U-55 welds 4&5, and u-rib U-33 weld 6.

The Caltrans QA Inspector observed welds with the following deficiencies: welding overlap, oversize welds, under-fill, and incomplete fusion. These indications observed at the welds were marked in yellow by the QA Inspector with a paint stick along the distance from the "Y" axis, starting at the weld start to the weld completion end.

The weld indications observed were recorded on a Caltrans spreadsheet for future reference. The QA Inspector also identified each u-rib inspected with a yellow triangle with the QA Inspector's Caltrans lot number B59, QA and date of inspection.

The following digital pictures illustrate u-rib deck plate panel DP299-001.

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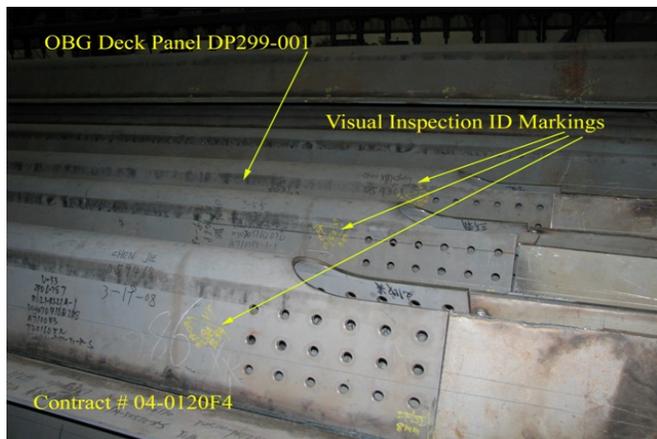
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# WELDING INSPECTION REPORT

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## Summary of Conversations:

As noted within the report shown above.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Dixon,Roscoe	Quality Assurance Inspector
<b>Reviewed By:</b>	Hager,Craig	QA Reviewer

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